Qty:

: HINGE BRACKET

: D35381

: 10254N/A

: 3/30/2007

:N/A

· D3538 REV.A

Üser:

Thursday, 3/8/2007 1:19:10 PM

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31123

Estimate Number

: 12543

P.O. Number

This Issue

First Issue

Written By

Comment

Previous Run

:NIA

: 3/8/2007 Prsht Rev.

Checked & Approved By

S.O. No. : NA

: 30866

Type

: MACHINED PARTS

New Issue 06-10.03 EC : Est Rev:A

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Bar 1.25 x 1.25"

3.9900 f(s) 0.1995 f(s)/Unit Total:

6061_T6 Bar 1,250" x 1.250 Batch:

ZD

2.0

BAND SAW



Comment: BAND SAW

Comment: Qty.:

Cut blanks 1.500" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #





Each

20 Um:

QC2

2-Deburr

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK





Comment: SECOND CHECK

6.0

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



Dart Aerospace Ltd

W/O:		WORK ORDER CHAN					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•					
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Part No:	PAR #:	Fault Category:	_ NCR: Yes No DQA:	Date: <u>07/03 / 1</u>
		,	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Correc	ctive Action Section		Verification	Annroyal	Approval	
STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector		
		-							
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Correct Initial A	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Portion Description Section B Section B Verification Approval Chief Eng	

NOTE: Date & initial all entries

Thursday, 3/8/2007 1:19:11 PM Date: User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HINGE BRACKET Job Number: 31123 Part Number: D35381 Job Number: Seq. #: **Machine Or Operation:** Description: POWDER COATING 7.0 POWDER COATING M103706 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 07 03 PACKAGING PACKAGING RESOURCE #1 9.0 to all Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

10.0

Job Completion

QC21

Comment: FINAL INSPECTION/W/O RELEASE

U 07:03:16

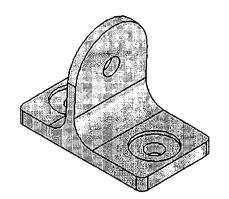
Dart Aerospace	Lta
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W/O:			WORK			K ORDER CHANGES						
DATE STEP				PROC	EDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAF	R #:		_ Fault Ca	itegory:	·	NCR: Yes	No DQ	A :	Date:	
		I	j					QA:	N/C Close	d:	Date: _	
NCR:			ļ	W	ORK OR	DER I	NON-CONFORMAN	CE (NC	R)		i :	
DATE	STEP	Description of	NC			Corr	ective Action Section E	Verific	cation	Approval	Approval	
DATE	SIEP	Section A	i 		Initial Chief Eng		Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector
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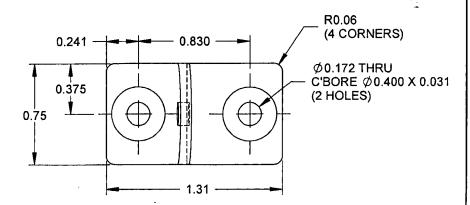
NOTE: Date & initial all entries

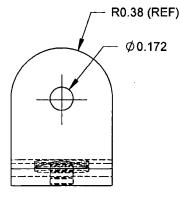


DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
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1 0	PH	一概	D3538	SHEET 1 OF 2		
DATE			TITLE	SCALE		
	06.10.13		HINGE BRACKET	1:1		
REV	REV DATE		DESCRIPT	ION		
Α		06.10.13	NEW ISSUE			

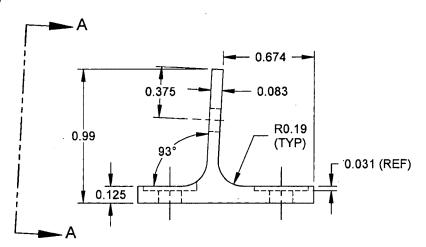


RELEASED









D3538-1 HINGE BRACKET

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B) ONTROLLED COPY 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

SHOP COPY RETURN TO ENGINFERING

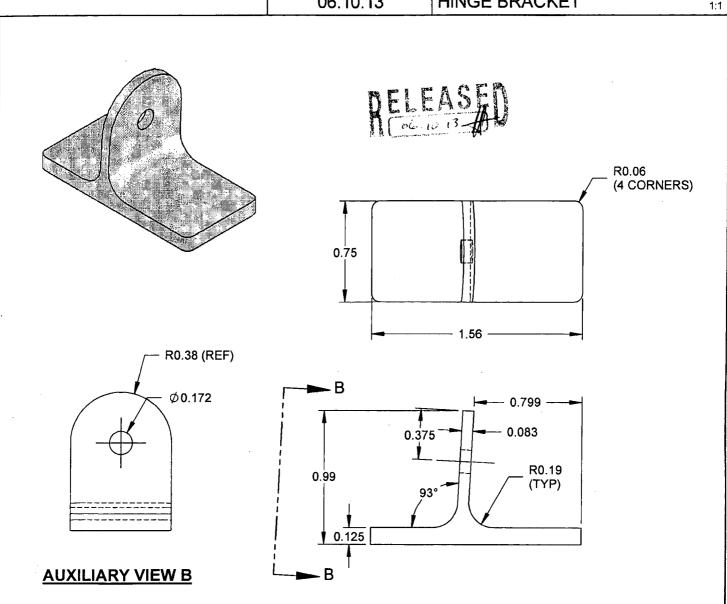
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017		D3538	SHEET 2 OF 2		
DATE		TITLE	SCALE		
I 06 1	IN 12	HINGE BRACKET			



D3538-3 HINGE BRACKET

SHOP COPY RETURNITO ENGINEERING

WITHOUT NOTICE

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M606) TROLLED COPY SUBJECT TO AMENDMENT

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD	Work Order:	31123	
Description: HINGE BRACKET	Part Number:	D3538-1	
Inspection Dwg: 1/3538, Rev: 4		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	lejest	Method of Inspection	Comments
0.241	1.005	0243	-			
0,830	±.005	0.829				
RO.06	± 030	R0.060			,	
80.172	± 609	20173			-	
20.480 x 0.031	±.010	26.400 X0.02				
1.31	1.030	1,317				
0.75	± 030	0.753				
0.375	<u> </u>	0.377				
0.99	£ .030	0.988				
261.0	±.016	0.122				
0.375	±.016	0.375				
0.033	±-010	0.087				and the same of th
0679	± 010	6.669				
R0.19	I-030	RO.190				
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Measured by:	9nl	Audited by:	Prototype Approval:	NIA
Date:	A7/03/14	Date: 07/03/14	Date:	•
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Rev	Date	Change	Revised by Approved
Α		New Issue	KJ/JLM